

Date: Tuesday, 08/07/2008 1:46:53 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT GUIDE PLATE		
Job Number	: 40372			Part Number	: D35897		
Estimate Number	: 13364			Drawing Number	: D3589 REV B PRELIM 08.06.26		
P.O. Number	:			Project Number	: N/A		
This Issue	: 08/07/2008	S.O. No.	:	Drawing Revision	: B PRELIM		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 15/07/2008 Qty: 1 Um: Each		
Previous Run	: 05027						
Written By	:						
Checked & Approved By	: <i>M</i>						
Comment	: Est Rev:A 08-06-05 new issue DD verified by:ec						

## Additional Product

**PRELIMINARY ISSUE**

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
		<b>Comment:</b> Qty.: 0.0650 sf(s)/Unit Total : 0.0650 sf(s) 304/316 .063 Sheet batch: <i>108090</i> <i>m 08 07 09</i>
2.0	WATER JET	FLOW WATER JET
		<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3589 Dwg Rev: <i>B prel</i> Prog Rev: <i>B prel</i> } <i>m 08 07 09</i> (1)
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<i>m 08 07 09</i> (1)
		<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		<b>ENGINEERING APPROVAL</b> <i>108.07.09</i> <i>E 08/07/09 ④</i>
		<b>Comment:</b> SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		<b>Comment:</b> NC BRAKE
		1- Bend as per Dwg D3589 <i>SB 08/07/09 ⑦</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/07/2008 1:46:53 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT GUIDE PLATE

Job Number: 40372

Part Number: D35897

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



5 08/07/08 ①

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



USED ON D3589-041  
B/N: B40366 08/07/08

*MS & Co*  
Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

08.07.08

① 08-07-14 ①

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



6 08.07.21

POSITIVE RECALL  
EFFECTIVE 08.07.21 AUTH 1  
RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

POSITIVE RECALL  
EFFECTIVE 08.07.08 AUTH 1  
RELEASED 08.07.21 DATE 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40372
Description: AFT Guide Plate	Part Number:	D3589-1
Inspection Dwg: D3589 Rev: B Prelim		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

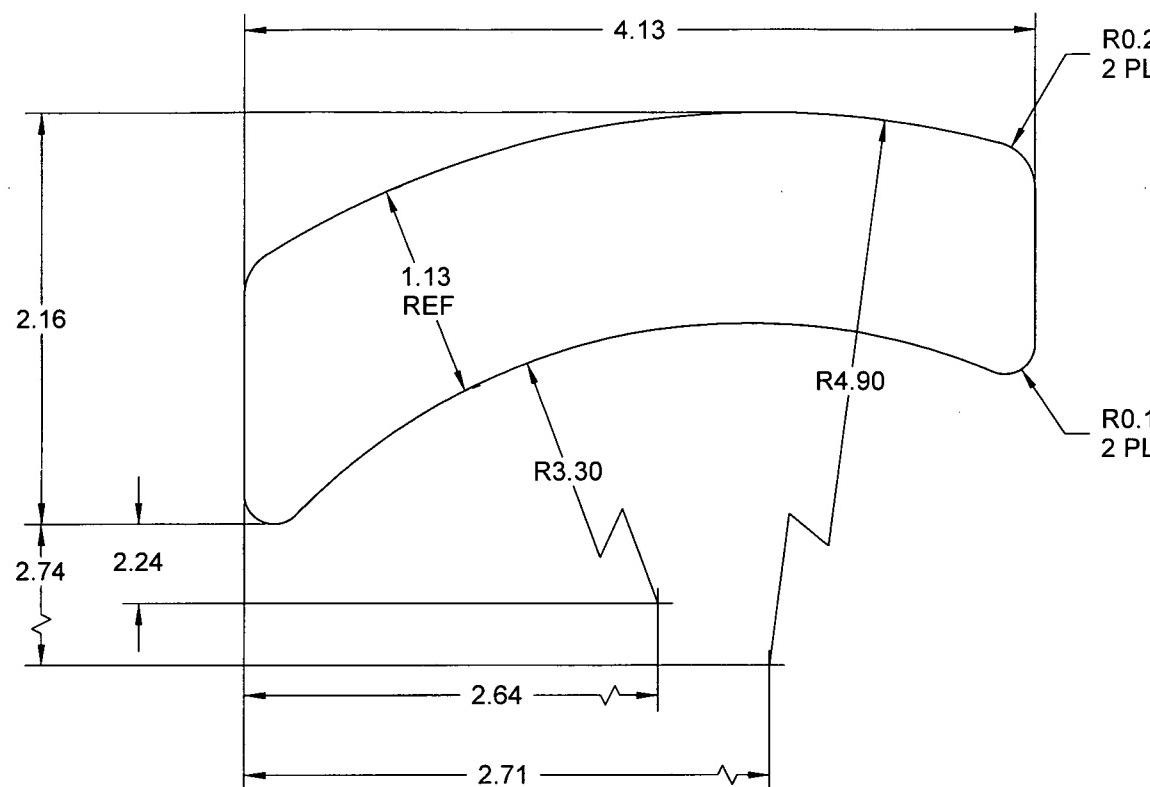
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Date:	08/01/09	Date:	08/01/09	Date:	A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	

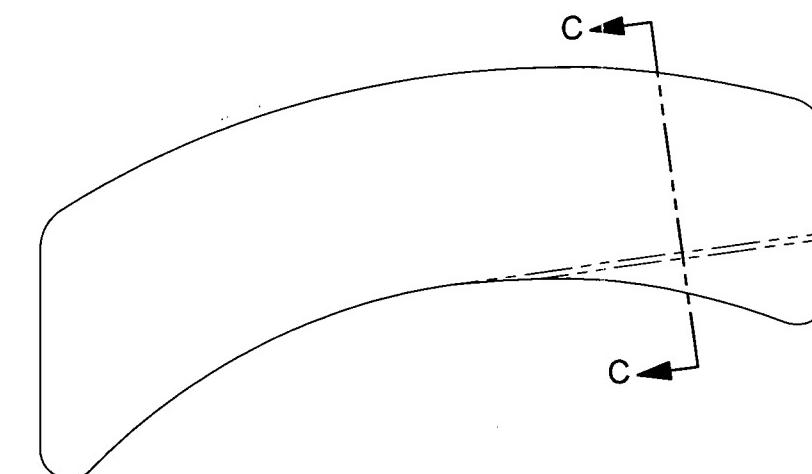
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D

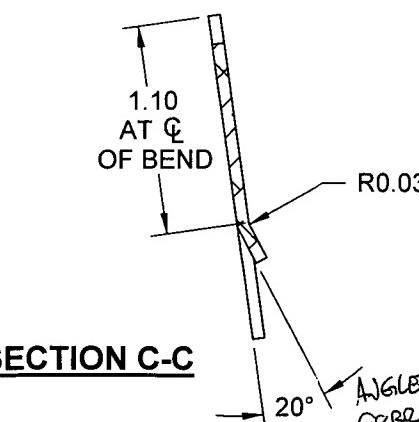
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**D3589-7F AFT GUIDE PLATE**  
**FLAT PATTERN**



**D3589-7 AFT GUIDE PLATE**  
MAKE FROM D3589-7F



**SECTION C-C**

40572

08.07.10

**PRELIMINARY ISSUE**  
→ 08.06.26

**D3589-7-7F NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH  
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. B
APPROVED		D3589
DE APPR.		SHEET 5 OF 8
DATE	08.06.25	TITLE
		SCALE
		LATCH ASSEMBLY
		NTS
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		WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Date: Tuesday, 08/07/2008 1:46:53 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT GUIDE PLATE		
Job Number	: 40372			Part Number	: D35897		
Estimate Number	: 13364			Drawing Number	: D3589 REV B PRELIM		
P.O. Number	:			Project Number	: N/A		
This Issue	: 08/07/2008 S.O. No. :			Drawing Revision	: B PRELIM		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 15/07/2008 Qty: 1 Um: Each		
Previous Run	: 05027						
Written By	:						
Checked & Approved By	: <i>[Signature]</i>						
Comment	: Est.Rev:A 08-06-05 new issue DD verified by:ec						

## Additional Product

PRELIMINARY ISSUE



Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet <i>C375</i>
		<i>ml 08 07 09</i>
Comment: Qty.: 0.0650 sf(s)/Unit Total : 0.0650 sf(s)	304/316 .063 Sheet batch: <i>108093</i>	
2.0	WATER JET	FLOW WATER JET 
Comment: FLOW WATER JET		 <i>ml 08 07 09</i>
	1-Cut as per Dwg D3589 Dwg Rev: <i>B prel</i> Prog Rev: <i>B prel</i>	 <i>ml 08 07 09</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  <i>ml 08 07 09</i>
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		 <i>ml 08 07 09</i>
4.0	QC8	SECOND CHECK <b>ENGINEERING APPROVAL</b>  <i>ml 08 07 09</i>
Comment: SECOND CHECK		 <i>ml 08 07 09</i>
5.0	BRAKE NC	NC BRAKE  <i>ml 08 07 09</i>
Comment: NC BRAKE		 <i>ml 08 07 09</i>
	1- Bend as per Dwg D3589	<i>SB 08 07 09</i>

## Dart Aerospace Ltd

## Receiving Slip

Date May 22, 2008	Page 1
Receipt Number RCP00007949	

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613) 632-3336  
Fax: (613) 632-4443

## Purchase From:

Campi Steel  
935 Boul. Du Havre  
Valleyfield, QC J6S 5L1

## Ship To:

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

**REFERENCE ONLY**

Reference	Description	Contact	Vendor Number	PO Number
			VC-CAM002	PO00006375

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M1010B0750X025	ASTM A21 Steel .75"x OR CSA G40-21, 38W/44W/50W/60W/70W MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 B/N108090	40.0000	f	6.250000	250.00	May 22, 2008
	M2024T3R1250	2024-T3 Round Bar 1.2 PER AMS-QQ-A-200/3 OR AMS 4152/4164/4165 MATERIAL: 2024-T3 OR T3510/T3511 ALUMINUM ROUND BAR B/N108090	12.0000	f	10.950000	131.40	May 22, 2008
	M2024T3S040	2024-T3 .040 sheet PER QQ-A-250/4 OR AMS 4037 MATERIAL: 2024-T3 ALUMINUM SHEET B/N108090	96.0000	sf	8.750000	840.00	May 22, 2008
	M2024T3S063	2024-T3 .063 sheet AS ABOVE B/N108090	96.0000	sf	14.150000	1,358.40	May 22, 2008
	M304S16GA	304/316 .063 Sheet PER MIL-S-5019 ANNEALED 2B FINISH MATERIAL: AISI 304/316 SS SHEET B/N108090	96.0000	sf	9.260000	889.44	May 22, 2008
	M6061T6TS1250W	6061T6 SQ TUBE 1.25 PER AMS-QQ-A-200/8 OR AMS 4160 PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR SQUARE TUBING MATERIAL: 6061-T6 OR 6061-R651/T6510/T6511/T62 B/N108090	20.0000	f	2.250000	45.00	May 22, 2008

## Comments:

THE MAD COUPLE

Digitized by srujanika@gmail.com

Digitized by srujanika@gmail.com

100-00000

- 95 -

THE MAU CORE.

1522

**MUD TEST CERTIFICATE**

Curriculum of MUL Test Results

898.99

37501

8 7 6 5 4 3 2 1

D

D

C

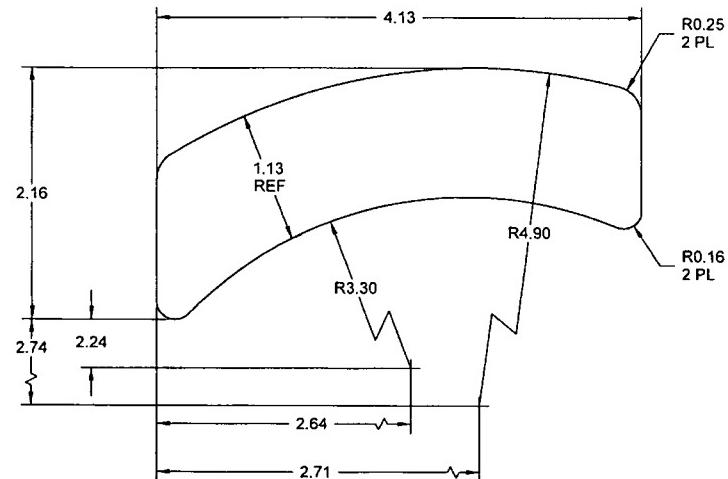
C

B

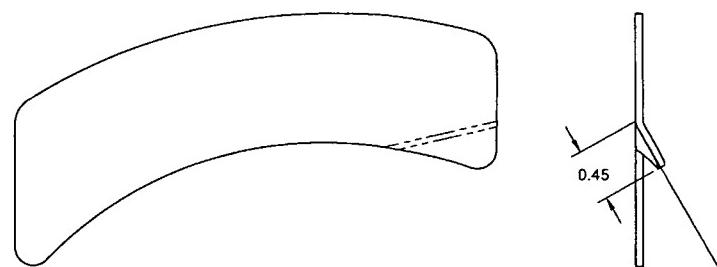
B

A

A



D3589-7F AFT GUIDE PLATE  
FLAT PATTERN



D3589-7 AFT GUIDE PLATE  
MAKE FROM D3589-7F

RELEASED  
09/22/05 MA

8 7 6 5 4 3 2 1

4037

- A D3589-7-7F NOTES:  
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524,  
 OR MIL-S-5059 (ANNEALED) 2B FINISH  
 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.09 lbs

DESIGN	<u>A</u>	DART AEROSPACE LTD
DRAWN	<u>A</u>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<u>A</u>	REV. B
MFG. APPR.	<u>A</u>	SHEET 5 OF 8
APPROVED	<u>A</u>	
DE APPR.	<u>A</u>	TITLE
		SCALE
		NTS
DATE	08.06.25	DATE

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